



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7703
Job Sheet 198472

Part No: 647.7703 Job Qty: 6 pcs
Part Name: Strut Assembly
 Status: New Priority: Medium
Part Weight: 0 lbs Job Tracking No:
Job Created: 7/30/19 Created By: Marie Lajeunesse
Due Date: 8/9/19 Description:
Type: SOLD
Note: DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Large Fab - Welded Assy-1	6 pcs	8/9/19		0.00	2.37	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MV
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
130	QC 9	6 pcs	8/9/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		12
							QC 9 - 9		
140	QC 5	6 pcs	8/9/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		



Container No: S203654



Part: 647.7703
Job No: 198472
Serial No/Batch: S203654
Revision:
Inspector:
Exp Date:
Instructions: Various STC's Date: 08/07/19

DART Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

			QC 5 - 50	GL
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
150	Outsource - 3 - Cadplate	6 pcs	8/9/19	
160	Packaging 2-1 - Receive - B4B	6 pcs	8/9/19	0.00 0.00
			GRO002-VC	10
			Packaging 2 - 1 - B4B	
			Packaging 2 - 2 - B4B	
			Packaging 2 - 3 - B4B	
			Packaging 2 - 5 - B4B	
			Packaging 2 - 4 - B4B	
			Packaging 2 - 6 - B4B	
			Packaging 2 - 7 - B4B	
			Packaging 2 - 8 - B4B	
			Packaging 2 - 9 - B4B	
			Packaging 2 - 10 - B4B	
			Packaging 2 - 11 - B4B	
			Packaging 2 - 12 - B4B	
			Packaging 2 - 13 - B4B	
			Packaging 2 - 14 - B4B	
			Packaging 2 - 15 - B4B	
			Packaging 2 - 16 - B4B	
			Packaging 2 - 17 - B4B	
			Packaging 2 - 18 - B4B	
			Packaging 2 - 19 - B4B	
			Packaging 2 - 20 - B4B	
			Packaging 2 - 21 - B4B	
			Packaging 2 - 22 - B4B	
			Packaging 2 - 23 - B4B	
			Packaging 2 - 24 - B4B	
			Packaging 2 - 25 - B4B	
			Packaging 2 - 26 - B4B	
			Packaging 2 - 27 - B4B	
			Packaging 2 - 28 - B4B	
			Packaging 2 - 29 - B4B	
			Packaging 2 - 30 - B4B	
			Packaging 2 - 31 - B4B	
			Packaging 2 - 32 - B4B	
			Packaging 2 - 33 - B4B	
			Packaging 2 - 34 - B4B	
			Packaging 2 - 35 - B4B	
			Packaging 2 - 36 - B4B	
170	QC 6	6 pcs	8/9/19	0.00 0.00
			QC 6 - 9	
			QC 6 - 68	
			QC 6 - 61	
			QC 6 - 40	
			QC 6 - 81	
180	Spray Paint - 2 - B4B	6 pcs	8/9/19	0.00 0.34
			Spray Paint - 1 - B4B	
			Spray Paint - 2 - B4B	
			Spray Paint - 3 - B4B	
			Spray Paint - 4 - B4B	
190	QC 14	6 pcs	8/9/19	0.00 0.00
			QC 14 - 15	
			QC 14 - 2	
			QC 14 - 34	
			QC 14 - 41	
			QC 14 - 51	
			QC 14 - 58	
			QC 14 - 59	
			QC 14 - 9	

				QC 14 - 68		
				QC 14 - 40		
				QC 14 - 19		
				QC 14 - 43		
				QC 14 - 24		
				QC 14 - 61	DAS 61	
				QC 14 - 81	9-89	
200	Packaging 3-1 - Stock - B4B	6 pcs	8/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	ML CCK114
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - SA	6 pcs	8/9/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	AUG 26 2019
					QC 21 - SA - 53	DAS 70 9-89

NL CCK114

AUG 26 2019

DAS
70
9-89

Part Op 120 - Weld per dwg A/R 4130 rod Batch: _____ - 1- ASSEMBLE AND WELD AS PER DWG ***IMPORTANT

Descriptions: DIMENSION IS 8.35" ***

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - QC5- Inspect part completeness to step on W/O

150 - Issue P/O : 44232 Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II ****NOTE: limite cad platting on thread to 0.003" or less****

160 - Receive & Inspect for Damage & Mat'l Certs

170 - INSPECT USING GO/NO GO GAUGE

180 - Spray Paint / NDT Room - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG 7195271

190 - QC14- Inspect Spray Paint

200 - Identify as per dwg & Stock Location: _____

210 - QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
647.7712	Strut Tube	6 pcs (1 ea)	120-Large Fab - Welded Assy-1	5187260
647.7713	Strut Thread	6 pcs (1 ea)	120-Large Fab - Welded Assy-1	5186898
647.7714	Strut Tube	6 pcs (1 ea)	120-Large Fab - Welded Assy-1	5190976
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7712	6	29	0
	647.7713	6	24	0
	647.7714	6	19	0
Part Specifications				
Specifications could not be found.				

Plex 7/30/19 10:04 AM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐											
Date :	Sequence #:	QTY Affected :		MRB (QS1042)											
Description Work Order Deviation				Disposition											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐											
										Completed By					
										Lead hand / Supervisor					
										QC / QA Coordinator					



DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044232



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044232
PO Date: 8/9/19
Due Date: 8/16/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

E-MAILED
2019-08-13

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198472	647.7703	Strut Assembly : Various STC's Issue P/O Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II ****NOTE: limite cad platting on thread to 0.003" or less****	Firmed		8/16/19	12 pcs	0 pcs	12 pcs	\$24.75/pcs	\$297.00
Grand Total:											\$297.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



Plex 8/13/19 9:44 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance
(021469-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip
021469 - 1

Livré à / Ship to
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
15-Aug-2019		Jigar Patel		POHB044232					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap	À venir / Back Order	
1	647.7703 Rev.	647.7703 01 -CAD YELLOW 0.0005 THICK OR LESS CAD PLATE IAW QQ-P-416F CLASS I TYPEII CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD MATERIAL STEEL BAKE LIMITE ON THREAD 0.003 THICK OR LESS	CADMIUM CH	12	12	0	0	0	
2	BAKE Rev.	BAKE 01 -BAKING, HYDROGEN EMBRITTLEMENT RELIEF	BAKE MIN-CHG	12	12	0	0	0	

OAS
81
9-89

RECEIVED
AUG 15 2019
DART AEROSPACE LTD.

AUG 15 2019

Notes Additionnelles / Additional Notes

1 BOX

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

JR JAY

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.